

5/30

DART AEROSPACE LTD

Work Order:

23769

Description: Handle Assembly

Part Number:

D3331-041

Dwg: D3331 Rev. B C

Qty:

20

05.07.06

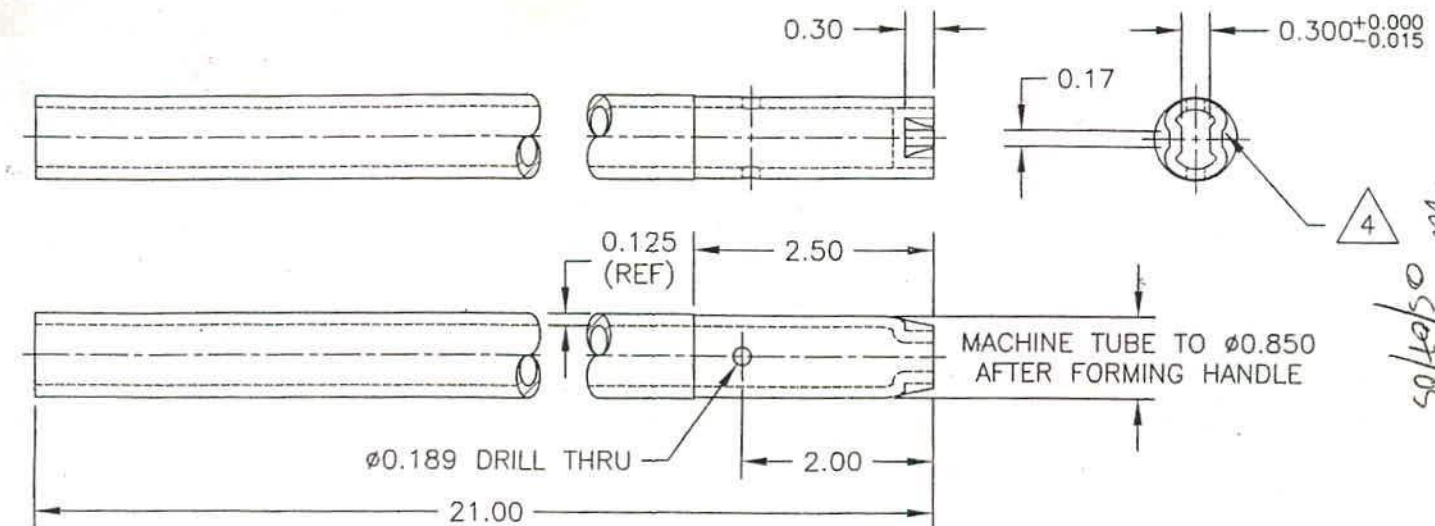
Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.07.06	20
2	MFA	Cut handle to finish length as per Dwg D3331 Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall (M1025TR0.875W.125) Identify for D3331-1 Batch: M17014	CPL	05/07/08	5
3	MFA	Form as per Dwg D3331 using DT8760 crimping Jig	CPL	05/07/08	5
4	CL	Turn as per Dwg D3331	CPL	05/07/08	5
5	QC2	Inspect parts as they come off the machine Identify as D3331-1	2	05-07-08	5
6	QC8	Second check	IE	05.07.08	5
7	MC	Deburr	CPL	05-07-08	5
8	MFA	Drill dowel hole as per Dwg D3331	CPL	05-07-08	5
9	MFA	Insert and Weld dowel as per Dwg D3331 Pick: Qty Part Number Description Batch 1 3/16"-1" long Dowel M16922 A/R N/A Steel Rod M14326	CPL	05-07-08	5
10	QC5	Inspect work to Step 9	M	05/07/12	5
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	M	05/08/11	5
12	QC3	Inspect Powder Coat	CL	05/08/11	5
14	MFA	Assemble as per Dwg D3331 Pick: Qty Part Number Description Batch 1 GP-78R Black Vinyl Grid M18060 1 D3158-050 Heat Shrink B22097 B24615 Identify as D3331-041	CPL	06-09-20	5
15	QC5	Inspect work to Step 14		06-09-25	5
16	ST	Identify and Stock		06/09/28	5
17	AC	Cost / part:		06-09-28	5
18	DC	Close W/O Inspect Level 21		06/09/28	5

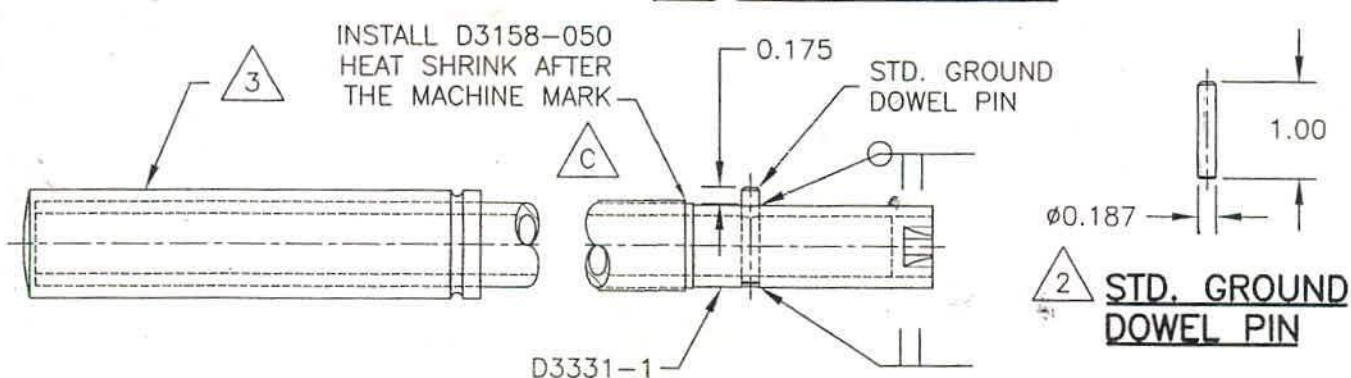
Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	
B	05.03.03	Revised Step 4 & 5	KJ/JLM	
C	05.05.26	Added D3158-050	KJ/JLM	

DART

RELEASED
05/07/05



1 **D3331-1 HANDLE**



D3331-041 HANDLE ASS'Y

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. C
05.05.20	D3331	SHEET 1 OF 1
	TITLE	SCALE
	HANDLE WELDMENT	1:2
A	04.11.29	NEW ISSUE
B	05.02.18	LENGTH 21.00 WAS 18.00
C	05.05.20	ADD D3158-050

- NOTES:
- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR0.875W.125)
 - 2) STD. GROUND DOWEL PIN, Ø3/16" x 1.00" LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-032
 - 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
 - 4) FORM USING TOOLING DT8760
 - 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
 - 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 7) ALL DIMENSIONS ARE IN INCHES
 - 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 23769

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:36 am

Work Order No : 0023769
Project Name : D3331-041
Project For : WK530
Work Order Type : Main
Main WO Number :
House Part Number : D3331-041
Description : Handle Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 15
Start Date : 07-06-05
Est Finish Date : 07-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
Part/All Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	87.19	100.00	87.19	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	17.66	100.00		
Production Cost :	0.00	286.77	100.00	209.10	77.67
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	373.96	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	373.96			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	1.18
Profits/(Loss) :	0.00	(-373.96)

MS 01/13
u
11.13

Date: Monday, 14/11/2005 8:53:52 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY
Job Number	: 23769		
Estimate Number	: 10439		
P.O. Number	:	Part Number	: D3331041
This Issue	: 14/11/2005 S.O. No. :	Drawing Number	: D3331 REV. C
Prsht Rev.	: NC	Project Number	:
First Issue	: / /	Drawing Revision	: C
Previous Run	:	Material	:
Written By	:	Due Date	: 15/12/2005 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	: Est: C 05.05.26 Added D3158-050 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1025TR0875W125	1025 Round Steel Bar
-----	-----------------	----------------------

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Cut handle to finish length as per Dwg D3331

2- Form as per Dwg D3331 using DT8760 crimping Jig

3.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE

Turn as per Dwg D3331

Identify as D3331-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

6.0	238032	3/16" Dowel Pin 1" long
-----	--------	-------------------------

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1- Deburr

2- Drill dowel hole as per Dwg D3331

3- Insert and Weld dowel as per Dwg D3331

Qty	Part Number	Description	Batch
A/R	N/A	Steel Rod	

Date: Monday, 14/11/2005 8:53:52 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY

Job Number: 23769

Part Number: D3331041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11.0

GP78R

Black Vinyl Grid

12.0

D3158

Heat Shrink

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg D3331

Identify as D3331-041

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 383*

RD 06/09/25



16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

